

Work Order ID 86922

86922

Page 1

July-09-12 11:05:39 AM

Item ID: D3072-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 7/09/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3072	Rev A1					⑤			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3072 (D3072-101 flat pattern)Dwg								
5052 .090	Rev: <u>A1</u> Prog Rev: <u>A1</u> 2-Deburr if necessary								B12-7-25
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									B12-7-25
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

SMB

12-7-25



12/4/25

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

160

Powdercoat

Memo

START TIME:

FINISH TIME: _____

OVEN TEMPERATURE:

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

Quality Control

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

Packaging

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 7/09/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/8/12
MLJ 12/08/10

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Picklist Print

July-09-12 11:05:39 AM

Page 1

Work Order ID: 86922

Parent Item: D3072-2

Parent Item Name: Bracket

Start Date: 7/09/12

Required Date: 8/03/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B02.01.18Flat pattern created on dash 101.NG
IPP Rev:C 08-02-26 now water jet DD verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090 5052-H32 .090 Sheet		Purchased	No			100	sf	52.6800	0.1167	0.4913684			

12-7-25

Location	Loc Qty	Loc Code
MAT022	52.68	
118641	11.22	
121780	32	
3019	9.46	

5

3019

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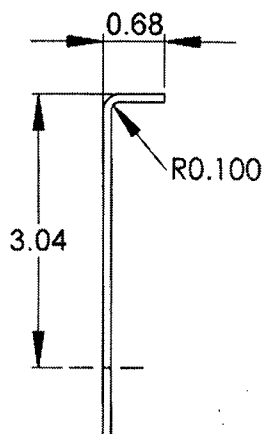
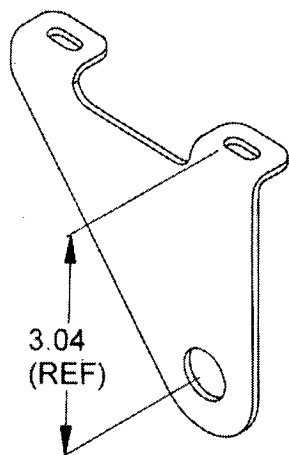
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3072	REV. A SHEET 1 OF 1
DATE 01.12.16	TITLE BRACKET		SCALE 1:1
A	01.12.16	NEW ISSUE	
A1 02.01.18		ADD FLAT PATTERN PART NUMBER H CP	



D3072-1/-2 BRACKET

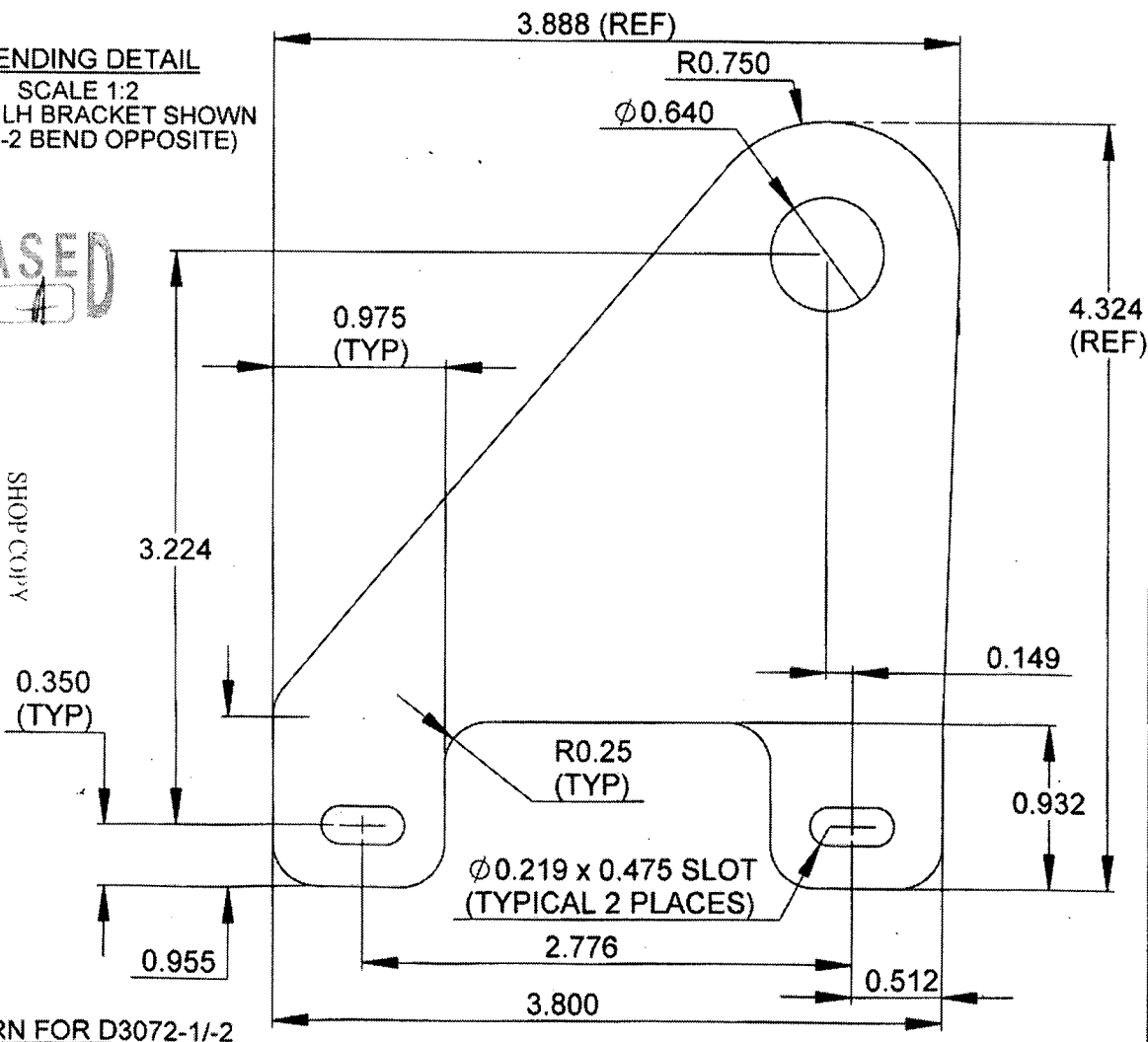
- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/ QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COATBLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL

SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02.01.15

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86922 M45
12/07/10



D3072-101

FLAT PATTERN FOR D3072-1/-2

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